

Date: Monday, 12/05/2008 10:02:15 AM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: INNER AFT SADDLE		
Job Number	: 39199			Part Number	: D5957		
Estimate Number	: 11082			Drawing Number	: D5957 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 12/05/2008 S.O. No. :			Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : MACHINED PARTS			Due Date	: 05/06/2008 Qty: 1		
Previous Run	: 38368				Um: Each		
Written By	:						
Checked & Approved By	: <u>Jul 08.5.12</u>						
Comment	: Est Rev:E Re-Format 05-11-29 JLM Est Rev:F ecn826 06.12.06 ec						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101007	Saddle Billet	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) D6101-007(7075-T7351) Size 2.50" x 7.50" X 8.25" (Grain along 7.50") Batch: <u>B 34875</u>	
2.0	HAAS3	HAAS CNC VERTICAL MACHINING #3	
		Comment: HAAS CNC VERTICAL MACHINING #3  1-Machine as per folio D5957, Ensure Batch Number is entered  2-Machine Keyway  3-Deburr & Tumble	
3.0	QC1	INSPECT ALL DIM TO DIM SHEET	
		Comment: INSPECT ALL DIM TO DIM SHEET	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	(1X)
		Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: INNER AFT SADDLE

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 POWDER COATING

POWDER COATING



m/07892



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 11:55

OVEN TEMPERATURE: 320°

FINISH TIME: 12:25

①

FL 08/05/28

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/05/28

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

C 08/05/28

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9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/28

Job Completion



MF 08-05-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	39199
Description: Inner Aft Saddle		Part Number:	D5957
Inspection Dwg: D5957	Rev: B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

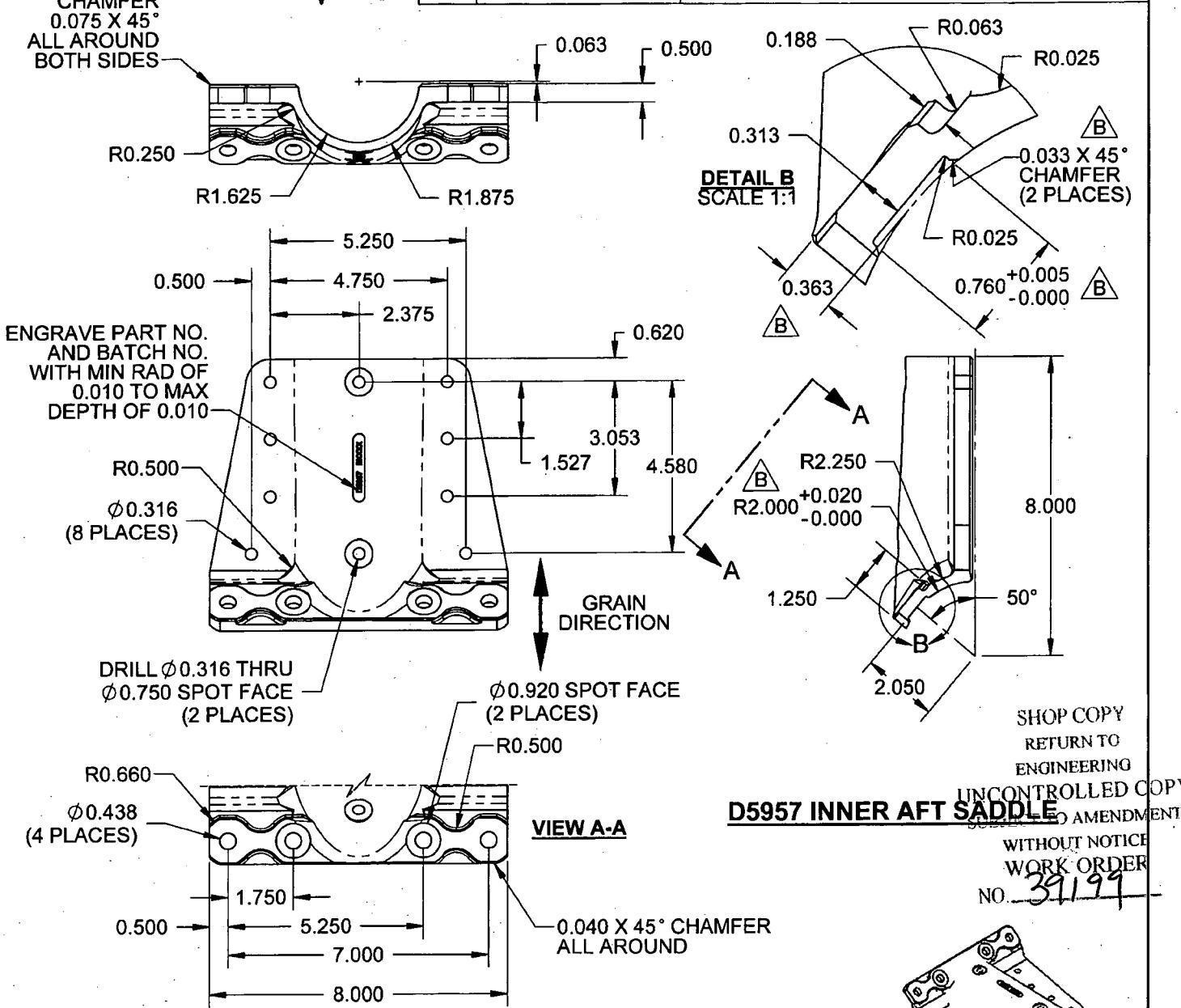
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		443					
B	1.745	1.755		1750					
C	5.245	5.255		5.250					
D	6.995	7.005		7.000					
E	5.240	5.260		5.250					
F	4.745	4.755		4.750					
G	0.315	0.322		.320					
H	1.522	1.532		1.528					
I	3.048	3.058		3.054					
J	4.575	4.585		4.580					
K	0.313	0.318		.318					
L	0.495	0.505		.500					
M	0.490	0.510		.498					
N	1.865	1.885		1.875					
O	7.990	8.010		7.997					
P	2.240	2.260		2.240					
Q	0.307	0.312		.311					
R	0.760	0.765		.760					
S	0.490	0.510		.498					
T	1.625	1.645		1.643					
U	2.000	2.020		2.011					
V	0.023	0.043		.033					
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	<i>8/8</i>	Audited by:	<i>5/28</i>
Date:	<i>08/05/28</i>	Date:	<i>08/05/28</i>

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	<i>DD</i>
F	08.04.21	Dimension E revised	KJ/DD	<i>DD</i>

**DART**

DESIGN <b>BW</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
CHECKED <b>CE</b>	APPROVED <b>#</b>	DRAWING NO. <b>D5957</b>	REV. B	SHEET 1 OF 1
DATE <b>06.11.07</b>		TITLE <b>INNER AFT SADDLE</b>	SCALE <b>1:4</b>	
REV	DATE <b>97.05.06</b>	DESCRIPTION <b>NEW ISSUE</b>		
<b>B</b>	<b>06.11.07</b>	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; $\phi$ 0.316 WAS $\phi$ 0.313; ADD TOLERANCE TO R2.000; ADD 0.363 DIM		

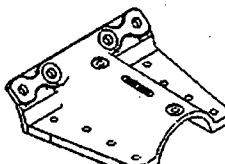


## NOTES:

**NOTE:**

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12  
(MAKE FROM D6101-007 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

**ISOMETRIC VIEW**  
**SCALE 1:8**



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